

Date: Wednesday, 06/05/2009 8:51:44 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: BEARPAW INSTALLATION KIT (13"X24" BENT)
<b>Job Number</b>	: 47762		
<b>Estimate Number</b>	: 12614		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D350578021
<b>This Issue</b>	: 06/05/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2672 REV B1
<b>First Issue</b>	: //	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 30840	<b>Drawing Revision</b>	: B1
<b>Written By</b>	:	<b>Material</b>	:
<b>Checked &amp; Approved By</b>	: <u>JLD 09-05-06</u>	<b>Due Date</b>	: 13/05/2009
<b>Comment</b>	Est Rev:A New Issue 07-01-02 JLM Est Rev:B New Manufacturing Method 08-10-29 JLM Verified By:EC		
<b>Qty:</b>	2	<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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*for JLD 09/05/20*



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D350-578-021 CHG005

*507-5121*

2.0	MFG ENGINEERING	MFG ENGINEERING
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Comment: MFG ENGINEERING

Program Batch Number

*J.F. 09/05/07*

3.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 4.8300 sf(s)/Unit Total : 9.6600 sf(s)

Material: Black UHMW 1"

Cut 2 blanks per (1) D206-559-025 Kit

Material: Black UHMW 1"

(MUHMWB10)

Batch: *111 384*

*B9-511*

*4*

4.0	WATER JET	FLOW WATER JET
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*B9-5-11*

Comment: FLOW WATER JET

Cut Blank as per File D2672\_BLANK

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

*mmf 09/05/14*

*SB 09/05/13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 06/05/2009 8:51:44 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION KIT (13"X24" BENT)

Job Number: 47762

Part Number: D350578021

Job Number:



Seq. #: Machine Or Operation: Description :

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA791 and Dwg D2672. Identify as D2672

3-Deburr

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

7/25/14

8/09/13

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

7/25/15

(2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

(Note: D2672B is on the BOM as material from step 3)

9.0

D2182B

Rubber Cushion



Comment: Qty.: 2.6250 f(s)/Unit Total: 5.2500 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion 45405

9/6/19

5/1

10.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block 44547

2 D2432F(ref only) Bearpaw

9/15/19

5/1

11.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp 53840

9/15/19

5/1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: BEARPAW INSTALLATION KIT (13"X24" BENT)

Job Number: 47762

Part Number: D350578021

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529

Washer

B45300

9/5/19

SD

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A

Bolt

M109061

9/5/19

SD

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416

Washer

M110363

9/5/19

SD

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

M110450

9/5/19

SD

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

9/5/19

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-578-021

Identify and Stock

Location: \_\_\_\_\_

DEVA

9/5/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 06/05/2009 8:51:44 AM  
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Drawing Name: BEARPAW INSTALLATION KIT (13"X24" BENT)

Job Number: 47762

Part Number: D350578021

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/22 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 9-05-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 47762
<b>Description:</b> Bearpaw		<b>Part Number:</b> D2672
<b>Inspection Dwg:</b> D2672	<b>Rev:</b> B1	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

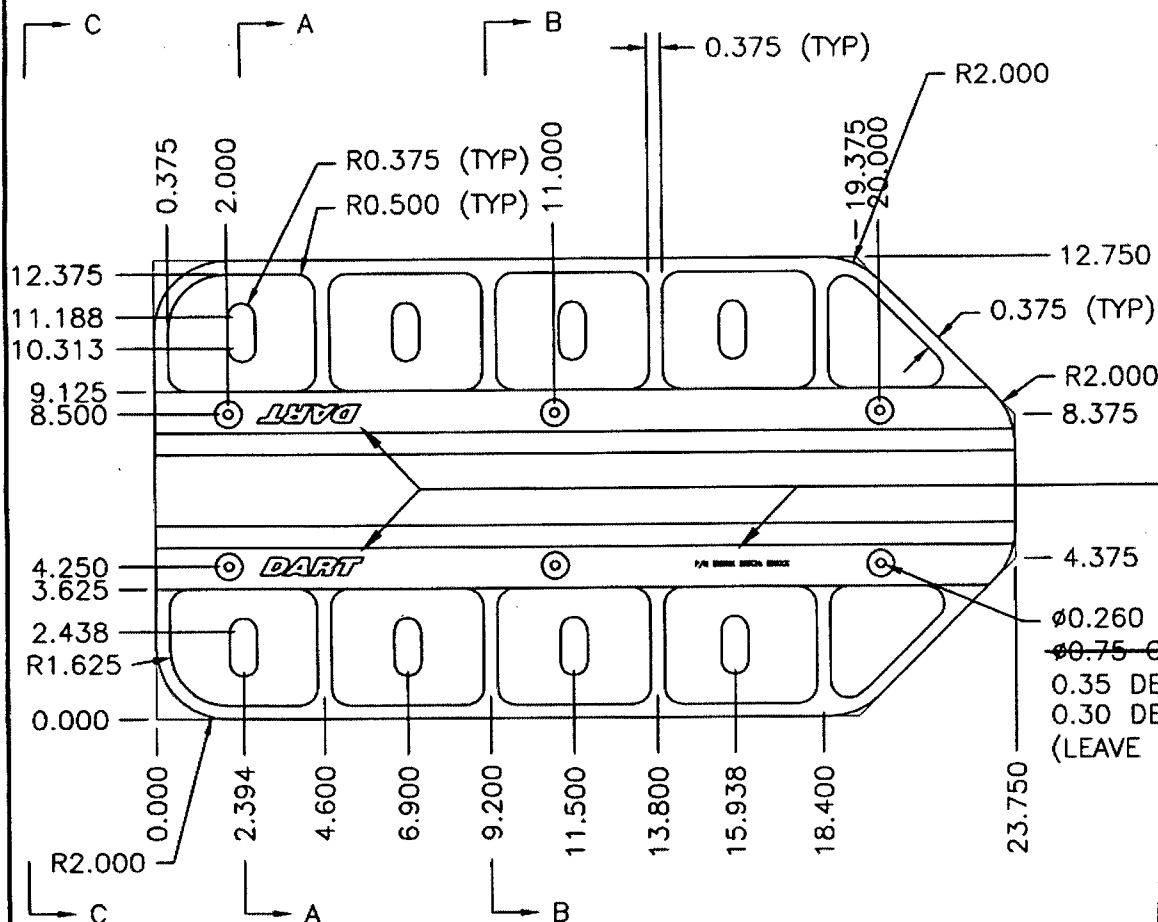
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	23.750	+/-0.030	23.750	✓			
B	12.750	+/-0.030	12.750	✓			
C	4.250	+/-0.010	4.257	✓			
D	2.000	+/-0.030	2.014	✓			
E	9.000	+/-0.010	9.000	✓			
F	0.375	+/-0.030	.374	✓			
G	9.000	+/-0.010	9.006	✓			
H	Ø0.260	+0.005/-0.000	.260	✓			
I	Ø0.93	+/-0.030	.924	✓			
J	0.300	+0.030/-0.000	.313	✓			
K	0.625	+/-0.030	.626				
L	0.063 x 45°	+0.030/-0.010	.068 x 45°	✓			
M	0.250	+/-0.010	.254	✓			
N	5.500	+/-0.030	5.507	✓			
O	R0.250	+/-0.030	.250	✓			
P	0.200	+/-0.030	.202	✓			
Q	0.25 x 45°	+/-0.030	.250	✓			
R	0.950	+0.030/-0.010	.955	✓			
S	0.375	+/-0.010	.376	✓			

<b>Measured by:</b> <i>SS</i>	<b>Audited by:</b> <i>mf</i>	<b>Prototype Approval:</b> N/A
<b>Date:</b> 01/05/13	<b>Date:</b> 09/05/15	<b>Date:</b>



Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF <i>af</i>	<i>+</i>

DESIGN	UNKNOWN	DRAWING NO.	REV. B
KE	KE	D2672	SHEET 1 OF 2
CHECKED M.H.	APPROVED S	DATE	SCALE
98.05.19		TITLE	1:5
A	97.04.08	BEARPAW	
B	98.05.19	NEW ISSUE	
91	22.10.22	CHANGE C'BORE, R1.58 WAS R1.50	

ENGRAVE LOGO TO  
MAX DEPTH OF  
0.012. ENGRAVE  
PART AND BATCH  
NUMBERS TO MAX  
DEPTH OF 0.010.  
(TYPICAL LOCATION  
AS ILLUSTRATED)



$\phi 0.260$  (TYP)  $\triangle B_1$   
 ~~$\phi 0.75$  C' BORE~~  $\phi 0.93$  C' BORE  
 0.35 DEEP FROM TOP (MIN.)  
 0.30 DEEP FROM BOTTOM  
 (LEAVE 0.300 MIN.)  $\triangle$


 43 C  
 TOP  
 BOTTOM  
 ) 

EFFECTIVE DEOS

93-06-17 K5

99-06-17 KE

## FLAT PATTERN

BEND AFTER MACHINING  
(D2672B ONLY)

D2672F: FLAT BEARPAW  
D2672B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

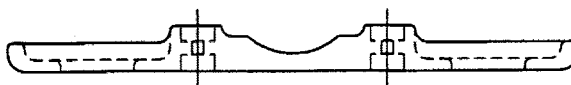
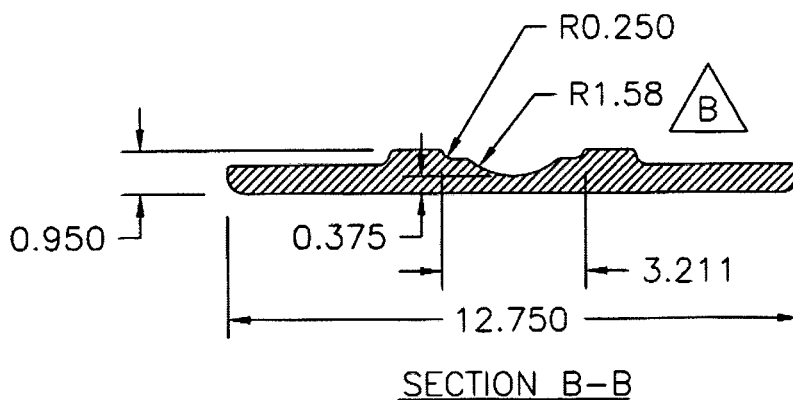
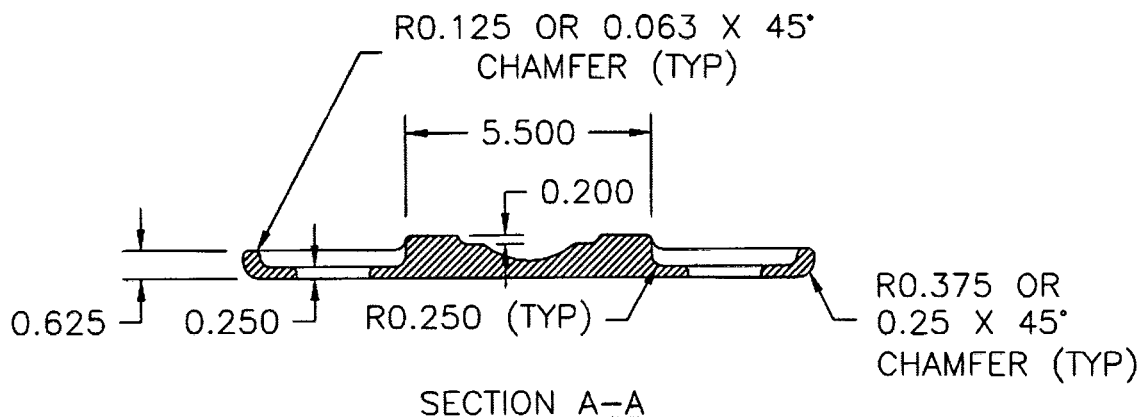
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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2672	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED  
99.06.17 KE



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